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TRANSLATION (HM-706PCT-original):

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OPTIMIZED SHIFTING STRATEGIES AS A  
FUNCTION OF STRIP WIDTH

^ This application is a 35 USC 371 of PCT/EP04/12796, filed 11/11/2004.

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The invention concerns a method for optimizing shifting strategies as a function of strip width for the best possible utilization of the advantages of CVC/CVC<sup>plus</sup> technology in the operation of strip edge-oriented shifting in four-high and six-high rolling stands, comprising a pair of work rolls and a pair of backup rolls and, in addition, in the case of six-high rolling stands, a pair of intermediate rolls, wherein at least the work rolls and the intermediate rolls interact with axial shifting devices, and wherein each work roll and intermediate roll has a barrel lengthened by the amount of the CVC shifting stroke with a one-sided setback in the area of the barrel edge.

In the past, quality requirements for cold-rolled strip with respect to thickness tolerances, attainable final thicknesses, strip crown, strip flatness, surfaces, etc., have steadily increased. In addition, the great variety of products on the market for cold-rolled plates is leading to an increasingly varied product spectrum with respect to the